

Work Order ID 133185

Tuesday, May 26, 2015 12:50:24 PM

133185

Page 1

Item ID: D3883-1

Revision ID:

Item Name: Saddle, Outboard LH

Start Date: 5/22/15 Start Qty: 10.00

Required Date: 5/26/15 Req'd Qty: 10.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: ALJ

Date: MAY 27 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3883	D

100

0.00

100

HAAS I

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

Program Batch No. 133185

Double check by: PD

1-Machine Step No 1 per Folio FA815 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA815 and inspect per Dimension Sheets

MILL AS PER DWG AND FOLIO FA815

FOLIO REV: C

DWG REV: D

DAS

44 15/07/06
9-89

DAS

40
9-89

105

0.00

105

Mill Conv

Conventional Milling Machine

Memo

0.00

MILL KEYWAY AS PER DWG

DAS

40
9-89

15/67/07

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Tuesday, May 26, 2015 12:50:24 PM

Item ID: D3883-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, Outboard LH
 Start Date: 5/22/15 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 5/26/15 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				2			DAS 44 9-89 15/07/06
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				2	0		DAS 20 9-89 15-07-07
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2x			DAS 36 9-89 15/07/07

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Tuesday, May 26, 2015 12:50:24 PM

Item ID: D3883-1 Accept ***N900040100*** Setup Start ***NS1***

Revision ID: Stop ***NS2***

Item Name: Saddle, Outboard LH

Start Date: 5/22/15 Start Qty: 10.00 ***10***

Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 10.00 ***10***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
140									
Powdercoat	Memo <i>M 131545.</i>	0.00							
Powder Coating	***MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT AS PER INDICATED ON DWG (SEE NOTE 2)***								
	DO NOT MASK INSIDE FLANGE SURFACE								
	START TIME: <i>8:10</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>8:40</i>								
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									

2 0 15.7.8. **DAS 34 989**

2 15/07/08 **DAS 51 989**

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Tuesday, May 26, 2015 12:50:24 PM

Item ID: D3883-1 Accept ***N900040100*** Setup Start ***NS1***

Revision ID: Stop ***NS2***

Item Name: Saddle, Outboard LH

Start Date: 5/22/15 Start Qty: 10.00 ***10***

Cust Item ID:

Required Date: 5/26/15 Req'd Qty: 10.00 ***10***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

Identify as per dwg & Stock Location: _____

0.00

160

Packaging

Memo

USED ON
w/ O 133769

0.00

Packaging

2 SAD 15/07/08

DA.
51
9-89

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

MLJ JUL 10 2015
JUL 09 2015

(Handwritten signature)

Picklist Print

Page 1

Tuesday, May 26, 2015 12:50:23 PM

Work Order ID: 133185

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Parent Item: D3883-1

D3883-1

Parent Item Name: Saddle, Outboard LH

Start Date: 5/22/15

Required Date: 5/26/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC
15.05.20 remove inside powdercoat DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-015		Manufactured	No			100	Each	2.0000	1	10			
D6101-015									**				
Saddle Billet													

DAS
44
9-89

15/07/06

Location Loc Qty Loc Code

MAT040

1

X 129885

1

MAT045

1

X 124323

1

133454

8

DART AEROSPACE LTD		Work Order: 133185
Description: Saddle, Outboard, LH		Part Number: D3883-1
Inspection Dwg: D3883	Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880		2.875	2.875	2.875			
B	1.433	1.443		1.438	1.438	1.438			
C	0.638	0.658		.645	.645	.645			
D	3.895	3.905		3.900	3.900	3.900			
E	0.257	0.262		.259	.259	.259			
F	0.605	0.625		.616	.617	.617			
G	1.120	1.130		1.125	1.125	1.125			
H	2.245	2.255		2.250	2.250	2.250			
I	2.000	2.020		2.0025	2.003	2.003			
J	0.140	0.165		.142	.147	.145			
K	0.240	0.260		.242	.245	.244			
L	0.115	0.135		.124	.125	.125			
M	0.140	0.165		.141	.147	.145			
N	0.720	0.780		.770	.775	.775			
O	0.240	0.260		.250	.252	.249			
P	0.110	0.140		.135	.135	.135			
Q	0.178	0.198		.188	.188	.188			
R	2.825	2.885		2.855	2.855	2.855			
S	0.316	0.321		.317	.317	.317			
T	0.990	1.010		1.006	1.000	1.000			
U	1.745	1.755		1.750	1.750	1.750			
V	5.990	6.010		6.001	6.001	6.001			
W	1.245	1.255		1.250	1.250	1.250			
X	0.490	0.510		.496	.500	.501			
Y	1.220	1.280		1.250	1.250	1.250			
Z	2.495	2.505		2.500	2.500	2.500			
AA	0.313	0.318		.316	.313	.313			
AB	0.020	0.040		.025	.025	.025			
AC	0.760	0.765		.760	.762	.760			
AD	0.215	0.220		.205	.218	.218			
AE	1.265	1.285		1.2675	1.2682	1.2680			
AF									
Accept/Reject				✗	✓				

Measured by: FK	DAS 40	Audited by: 20	DAS 9-89
Date: 15/07/06		Date: 9-89	1507-07

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	

DART AEROSPACE LTD		Work Order: 133185
Description: Saddle, Outboard, LH		Part Number: D3883-1
Inspection Dwg: D3883	Rev. <i>DS</i>	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880							
B	1.433	1.443							
C	0.638	0.658							
D	3.895	3.905							
E	0.257	0.262							
F	0.605	0.625							
G	1.120	1.130							
H	2.245	2.255							
I	2.000	2.020							
J	0.140	0.165							
K	0.240	0.260							
L	0.115	0.135							
M	0.140	0.165							
N	0.720	0.780							
O	0.240	0.260							
P	0.110	0.140							
Q	0.178	0.198							
R	2.825	2.885							
S	0.316	0.321							
T	0.990	1.010							
U	1.745	1.755							
V	5.990	6.010							
W	1.245	1.255							
X	0.490	0.510							
Y	1.220	1.280							
Z	2.495	2.505							
AA	0.313	0.318							
AB	0.020	0.040							
AC	0.760	0.765							
AD	0.215	0.220							
AE	1.265	1.285							
AF									
Accept/Reject									

Measured by:	
Date:	

Audited by:	
Date:	

Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order: 133185
Description: Saddle, Outboard, LH		Part Number: D3883-1
Inspection Dwg: D3883 Rev. C		Page 1 of 1

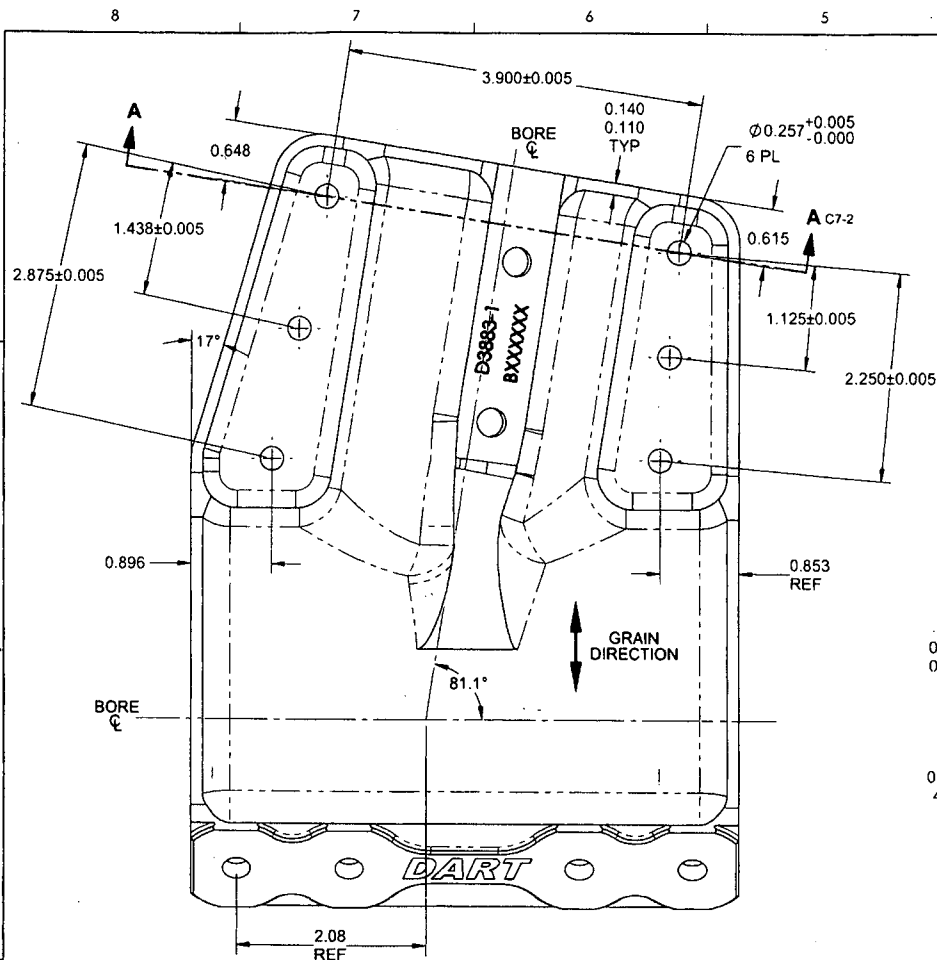
Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	2.870	2.880							
B	1.433	1.443							
C	0.638	0.658							
D	3.895	3.905							
E	0.257	0.262							
F	0.605	0.625							
G	1.120	1.130							
H	2.245	2.255							
I	2.000	2.020							
J	0.140	0.165							
K	0.240	0.260							
L	0.115	0.135							
M	0.140	0.165							
N	0.720	0.780							
O	0.240	0.260							
P	0.110	0.140							
Q	0.178	0.198							
R	2.825	2.885							
S	0.316	0.321							
T	0.990	1.010							
U	1.745	1.755							
V	5.990	6.010							
W	1.245	1.255							
X	0.490	0.510							
Y	1.220	1.280							
Z	2.495	2.505							
AA	0.313	0.318							
AB	0.020	0.040							
AC	0.760	0.765							
AD	0.215	0.220							
AE	1.265	1.285							
AF									
Accept/Reject									

Measured by:	
Date:	

Audited by:	
Date:	

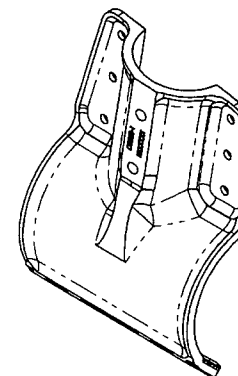
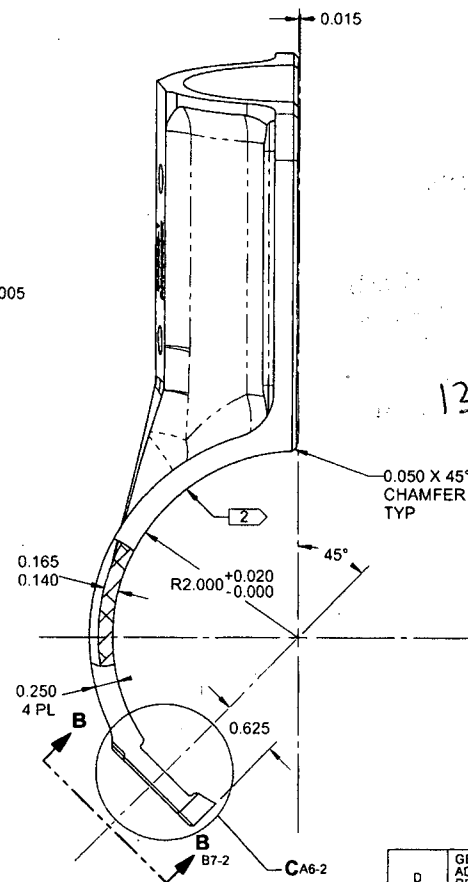
Rev	Date	Change	Revised by	Approved
A	09.10.22	New Issue	KJ	JLM
B	09.11.25	Dimension AE added	KJ	



D3883-1 SADDLE, OUTBOARD LH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO
MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-1-REVD.SLDPRT"



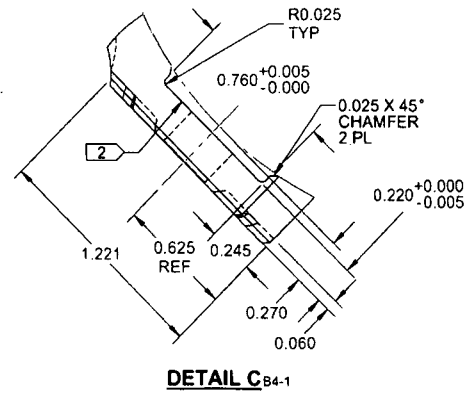
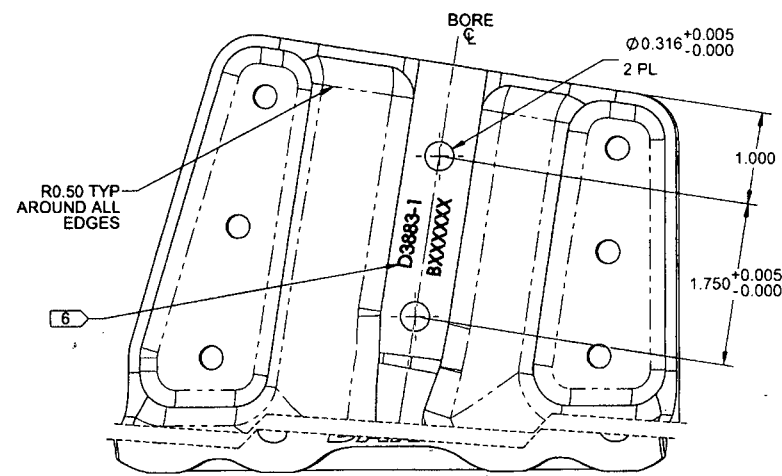
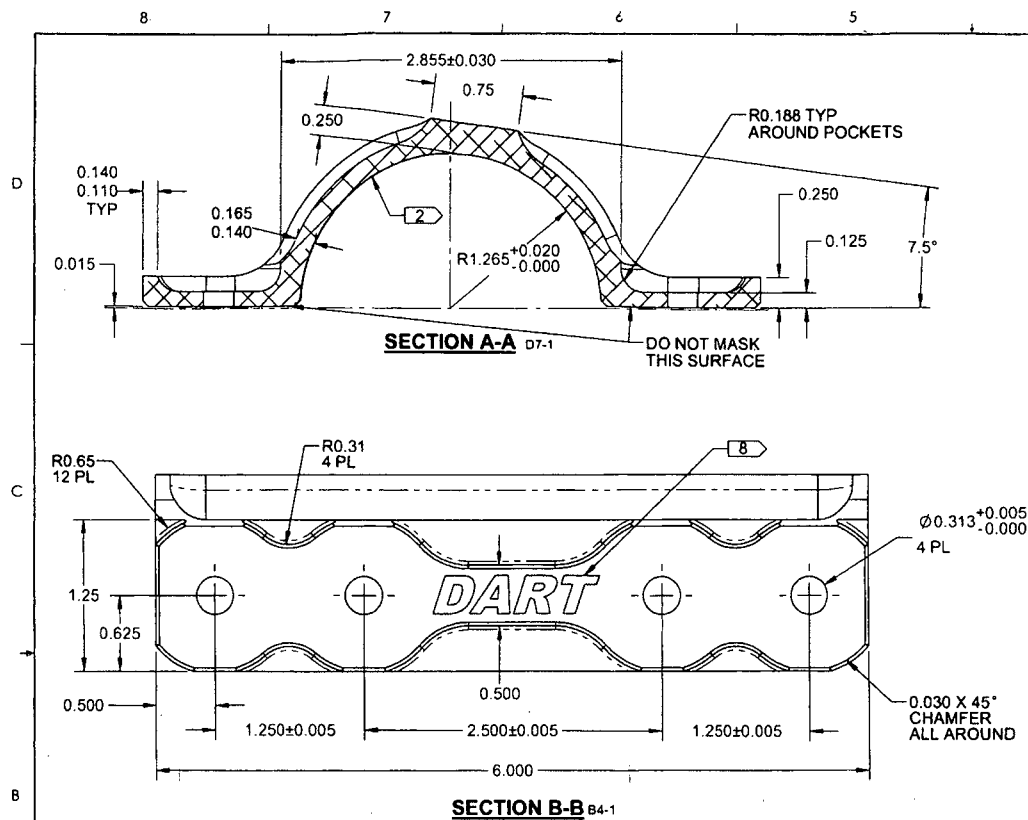
133185 MWS
150527

RELEASED

2015 MAY 19
A.P. EENIS-575

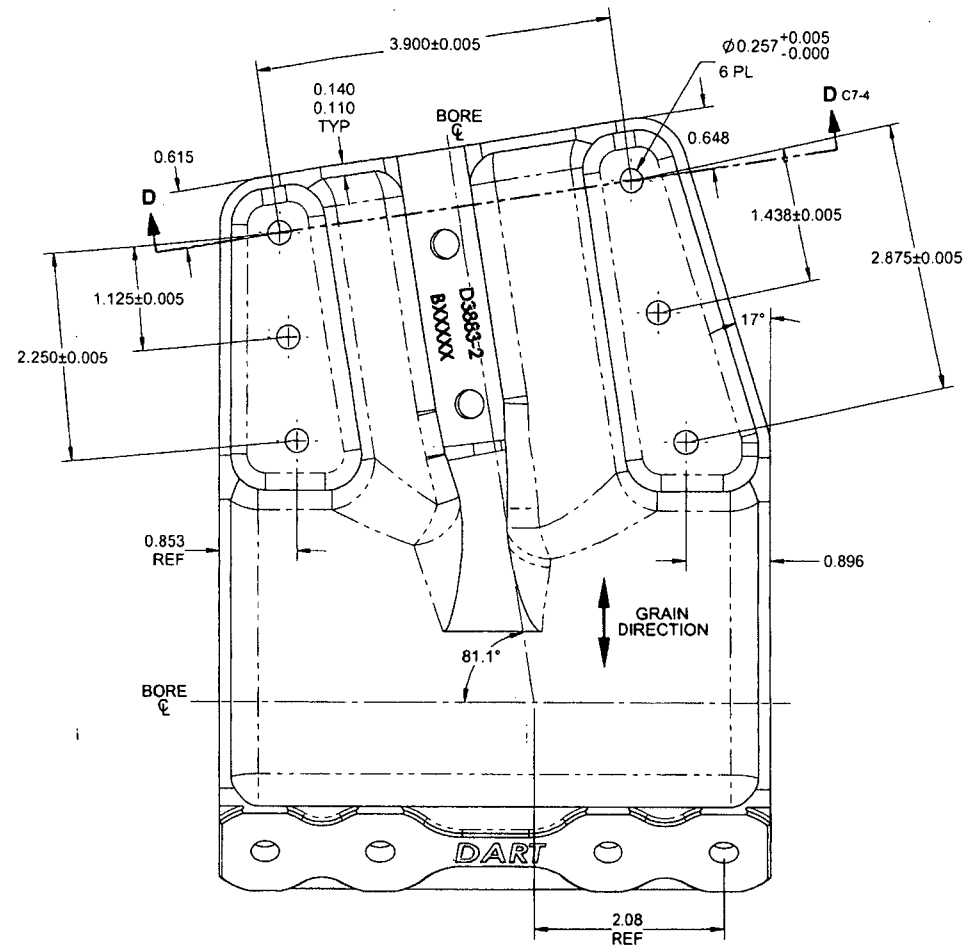
D	GENERAL REDRAW, ADDED D3883-2 ON SHEETS 3 & 4. ADDED NOTE 9 & REMOVED UNNECESSARY DIMS REMOVED POWDER COAT ON INSIDE SURFACE OF D3883-1/2	AP	15.02.11
C	ADD R1.265 (ZN D6-2)	RF	09.11.09
B	D6101-015. ZN A7-1; ADD 0.648; ZN D7-1; ADD 0.615. ZN D6- 1; ADD 0.125. ZN D7-2; ADD 0.060 & R0.031. ZN B5-2; 0.75 WAS 0.728. ZN C7-2	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	JLM	D3883	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	D3	OUTBOARD SADDLE	NTS
DATE	15.02.11	COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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A.R. 2015 MAY 19

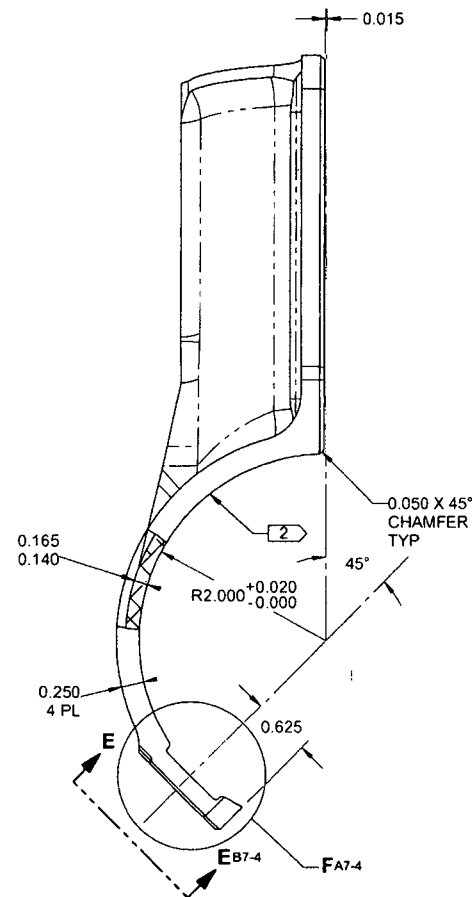
APPROVED	DESIGN	AP	DART AEROSPACE USA, INC.	
	DRAWN	AP	KENT, WA	
	CHECKED	AJS	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D3883	SHEET 2 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD SADDLE	NTS
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D3883-2 SADDLE, OUTBOARD RH

NOTES:

- 1) MATERIAL: 7075-T7351 ALUMINUM PER AMS-QQ-A-250/12, OR QQ-A-250/12 OR ASTM B209 (REF DART SPEC. D6101-015)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
MASK INSIDE SURFACES OF SADDLE PRIOR TO APPLICATION OF POWDER COAT
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX. DEPTH OF 0.010 WITH A MIN. TOOL RAD OF R0.010
- 7) WEIGHT: 1.03 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD R0.250
- 9) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D3883-2-REVD.SLDPRT"



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P. 2015 MAY 19

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DESIGN	AP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	JLM	D3883	SHEET 3 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD SADDLE	NTS
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